

shp ASAP D3562 all done *un assembled

Work Order ID 88732

88732

Page 1

August-01-12 6:55:33 AM

Item ID: D3562-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Step Assembly, LH

Start Date: 8/01/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/06/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3562

Rev E

100

0.00

100

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2622 extrusion as per Dwg D3562
2-Deburr and bevel ends for welding

110

QC6- Inspect dimensions to drawing

0.00

110

QC

Memo

0.00

Quality Control

120

Chemical Conversion Coat per QSI005 4.1

0.00

120

HandFinish

Memo

0.00

Hand Finishing

1 0 12.08.01

1x 12.08.01

1 12.08.01

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August-01-12 6:55:33 AM

Item ID: D3562-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Assembly, LH
 Start Date: 8/01/12 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 8/06/12 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				1	0		LK 12.08.01
140 *140* Small Fab Small Fab	Small Fab Memo 1- Transfer drill Rivet holes as per dwg D3562. 2-Touch-up rivet holes with alodine as per dwg d3562 3-Rivet legs using Magnabond as per dwg D3562. *****Ensure to wipe off any excess magnabond ***** A/R Magnabond 6398 Batch: m1206dd6	0.00 0.00				1	0		Ac 12.08.02
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							(AT) 44

DAS
16
8-83

12/08/02

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LP

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August-01-12 6:55:33 AM

Item ID: D3562-041 Accept ***N900040100*** Setup Start ***NS1***
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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				1	8	20	12/08/02
200 *200* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: 7h20 OVEN TEMPERATURE: 320°F FINISH TIME: 7h50	0.00 0.00 W.121841				1	8	20	12/08/03
210 *210* HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4:4 Batch 122500 Memo	0.00 0.00				1	8	20	12/08/03

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August-01-12 6:55:33 AM

Item ID: D3562-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Assembly, LH
 Start Date: 8/01/12 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 8/06/12 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	QC3- Inspect Part Finish	0.00							
220									
QC	Memo	0.00							
Quality Control									
230	Identify as per dwg & Stock Location: _____	0.00							
230									
Packaging	Memo	0.00							
Packaging									
240	QC21- Final Inspection - Work Order Release	0.00							
240									
QC	Memo	0.00							
Quality Control									

1641 6 11 10 03

2/8/32

M5 12/08/03

M5 12/08/03

Picklist Print

August-01-12 6:55:32 AM

Page 1

Work Order ID: 88732

Parent Item: D3562-041

Parent Item Name: Step Assembly, LH

Start Date: 8/01/12

Required Date: 8/06/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 06-11-09 JLM
 IPP rev B ECN 987 07.10.09 EC verified by: DD
 IPP Rev:C ECN1048 07-12-18 DD verified by:ec
 IPP Rev:D 08-07-28 add chemical conversion coat DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2622-120C Step Extrusion		Manufactured	No			100	Each	95.8900	1	1		12-08-01	

Location	Loc Qty	Loc Code
HALL	16.37	
46910	2	
64409	6	
66970	7.7	
68293	0.25	
72131	0.42	
WA	70.16	
81507	2.88	
83894	67.28	(1)
WA013	9.36	
75781	2	
77612	7.36	

D2734
Step End Plate

Manufactured No

140 Each 89.0000

2 2

12-08-01

Location	Loc Qty	Loc Code
WA	89	
80682	8	
84563	41	2
88089	40	

D3560-041
Arm Weldment

Manufactured No

140 Each 0.0000

1 1

12-08-01

D3560-043
Arm Weldment

Manufactured No

140 Each 0.0000

1 1

12-08-01

B 80259 = (1)
 B 80261 = (1)

Picklist Print

August-01-12 6:55:33 AM

Page 2

Work Order ID: 88732

Parent Item: D3562-041

Parent Item Name: Step Assembly, LH

Start Date: 8/01/12

Required Date: 8/06/12

Start Qty: 1.00

Required Qty: 1.00

MS20600-AD4W5

Purchased

No

160

Each

519.0000

32

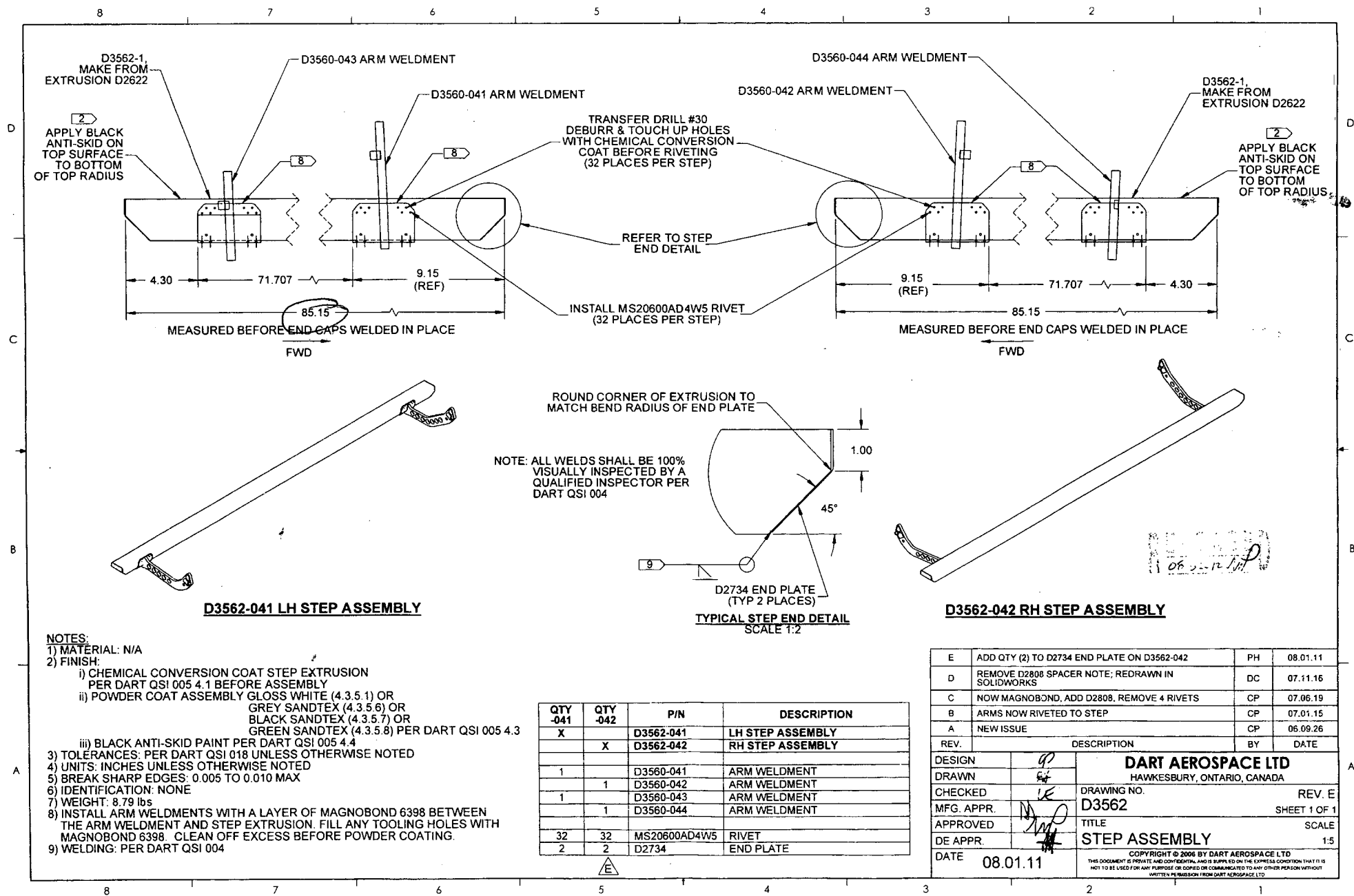
32

Blind Rivet

M 18.384 (x32)

Ac 12.08.02

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST321	519	
121255	19	
121349	200	
121652	300	



QTY -041	QTY -042	P/N	DESCRIPTION
X	X	D3562-041	LH STEP ASSEMBLY
		D3562-042	RH STEP ASSEMBLY
1		D3560-041	ARM WELDMENT
	1	D3560-042	ARM WELDMENT
1		D3560-043	ARM WELDMENT
	1	D3560-044	ARM WELDMENT
32	32	MS20600AD4W5	RIVET
2	2	D2734	END PLATE

E	ADD QTY (2) TO D2734 END PLATE ON D3562-042	PH	08.01.11
D	REMOVE D2808 SPACER NOTE; REDRAWN IN SOLIDWORKS	DC	07.11.16
C	NOW MAGNOBOND, ADD D2808, REMOVE 4 RIVETS	CP	07.06.19
B	ARMS NOW RIVETED TO STEP	CP	07.01.15
A	NEW ISSUE	CP	06.09.26
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3562	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		STEP ASSEMBLY	1:5
DATE	08.01.11	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
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Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Request For Quote ☐
 Sale Order ☐
 Purchase Order ☒

Date of Creation
 31-Jul-2012

RFQ/S.O./P.O. Number

Customer Billing Details	
Sales Rep:	
Customer Name:	Bristow US LLC
Contact Name:	Mike Kirkendall
Customer P.O.:	Warranty CSR12-113PO 739085
Customer Code:	
Customer Billing Details Shaded areas must be filled in	Address
	City / State
	Postal Code
	Country
Customer Phone:	
Customer Fax:	
Customer Cell:	
Customer Website:	
Contact e-mail:	
Return Authorization	
Non Conformance	CSR12-113

Shipping Instructions	
Company Name:	Bristow Alaska Inc
Contact Name:	Mike Kirkendall
Contact Phone:	907-452-1197
Special Instructions:	
Customer Shipping Details Shaded areas must be filled in	Address
	City / State
	Postal Code
	Country
Method of Payment:	N/A
Card Holder Name:	N/A
Credit Card #:	N/A
ABN / IRS / GST #:	
Freight Forwarder:	Federal Express
Account #:	1517-9324-0 DAS
Type of Service:	Int'l Priority
Ppd/Chg USD <input type="checkbox"/>	Customs Included <input type="checkbox"/>
Collect <input type="checkbox"/>	USD <input type="checkbox"/>
Prepaid USD <input checked="" type="checkbox"/>	N/A \$

Product Order List

Item	Qty	Product Number	Product Availability	Product Description	Batch Number	Supplier	Unit Retail Price	Customer Discount	Discount Per Unit	Customer Invoice Amount	DHS Commission	DHS Invoice Amount
1	1	D3562-041	1-2 wks	Step Weldment		DAS	\$ -	100%	\$ -	\$ -	0%	\$ -
2							\$ -	0%	\$ -	\$ -	0%	\$ -
3							\$ -	0%	\$ -	\$ -	0%	\$ -
4							\$ -	0%	\$ -	\$ -	0%	\$ -
5							\$ -	0%	\$ -	\$ -	0%	\$ -
6							\$ -	0%	\$ -	\$ -	0%	\$ -
7							\$ -	0%	\$ -	\$ -	0%	\$ -
8							\$ -	0%	\$ -	\$ -	0%	\$ -
9							\$ -	0%	\$ -	\$ -	0%	\$ -
10							\$ -	0%	\$ -	\$ -	0%	\$ -
11							\$ -	0%	\$ -	\$ -	0%	\$ -
12							\$ -	0%	\$ -	\$ -	0%	\$ -
13							\$ -	0%	\$ -	\$ -	0%	\$ -
Sub Total										\$ -		\$ -
Freight										\$ -		\$ -
Total										\$ -		\$ -

All figures are in US dollars

DHS INTERNAL
CSR12-113. Replacement step weldment for D412-630-023 B22511, per agreement BBeckett & PMcDonald. Ship Aug 15 or sooner.

COMMENTS FOR PURCHASE ORDER
ON PACKING SLIP: CSR12-113. Replacement step weldment for D412-630-023 B22511.

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

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		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other